Work Order ID 104572

July-12-13 10:25:10 AM

D2565-105
B104572
~~D2012-106~~ ~~B10513~~

104572

Item ID: D2565-105

Revision ID:

Item Name: Strut

Accept *N900040100*

Setup Start *NS1*
Stop *NS2*

Start Date: 7/12/13 **Start Qty:** 5.00 *5*

Required Date: 7/12/13 **Req'd Qty:** 5.00 *5*

Cust Item ID:

Customer:

Reference:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** MLS **Date:** 13-07-16 **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D2565	Rev E

SB 13/10/10

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100 *100* Brake NC Brake NC	NC BRAKE **Memo** Punch as per Dwg D2565 usingDT 8313	0.00 0.00	5			
110 *110* Small Fab Small Fab	Small Fab **Memo** Drill hole open to .316 Ø as per Dwg D2565 (one end only) Deburr	0.00 0.00	5x		13/10/21	DAS 36 9-89
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 DAS 27 9-89 0.00 13\10-21	S			

DQA: ____________ Date: ____________

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date:

Work Order update only ☐

Work Order: ____________	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Part No. ____________	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. ____________	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Folio/Program	☐ Outside Dimensions	☐ Pressure/Forced
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance	☐ Set-up
☐ Cracks	☐ Broken/Damage/Defect	☐ Hardware	☐ Part Incorrect	☐ Temperature/Cure
☐ Crimp/Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified	☐ Part Lost/Missing	☐ Weld
☐ Cuffs	☐ Contamination	☐ Instructions Incomplete/Unclear	☐ Part Moved	☐ Wrong Stock Pulled
☐ Crushing	☐ Countersink	☐ Misaligned/off center	☐ Positioned Wrong	
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Power Loss/Surge	☐ Other
☐ Inspection Strip in Tube	☐ Drawing	☐ Misread		
☐ Marks/Chatter	☐ Drill Holes	☐ Off-set		
☐ Turning Sequence	☐ Finish	☐ Out of Calibration		
☐ Wave/Twist in Tube	☐ Fit/Function	☐ Out of Sequence		

Work Order ID 104572 *104572*

July-12-13 10:25:10 AM

Item ID:	D2565-105		**Accept**	*N900040100*	**Setup** Start *NS1*
Revision ID:					Stop *NS2*
Item Name:	Strut				
Start Date:	7/12/13	**Start Qty:** 5.00	*5*	**Cust Item ID:**	
Required Date:	7/12/13	**Req'd Qty:** 5.00	*5*	**Customer:**	
Reference:					

Run Start *NR1* Stop *NR2*

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel M126125	0.00				5	∅	13-11-21	DAS 34 9-89
	Memo START TIME: 11:50 OVEN TEMPERATURE: 400° FINISH TIME: 12:00	0.00							
140 *140* QC Quality Control	QC3- Inspect Part Finish	0.00 DAS 27 9-89				5			
	Memo	0.00 13 10 21							
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: (1x) ST252	0.00				5x	DAS 28 9-89	13-10-21	
	Memo (4x) PP 107578	0.00							

DQA: ________ Date: ________

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date:

Work Order update only ☐

Work Order: ________

Part No. ________

NCR No. ________

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Folio/Program	☐ Outside Dimensions	☐ Pressure/Forced
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☐ Turning Sequence	☐ Finish	☐ Out of Calibration		
☐ Wave/Twist in Tube	☐ Fit/Function	☐ Out of Sequence		

Picklist Print

July-12-13 10:25:10 AM

Work Order ID: 104572

Parent Item: D2565-105

Parent Item Name: Strut

Start Date: 7/12/13

Start Qty: 5.00

Required Date: 7/12/13

Required Qty: 5.00

Comments: IPP: F02.04.16Added dwg Rev.C1NG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049 304 RD Tube .750 x .049W		Purchased	No			100	f	466.3989	**1.6825**	**8.855263**	SB	13/10/6	

Location		Loc Qty	Loc Code
MAT017		466.3988825	
	122312	13.3	
	122468	0.0000325	
	124768	56.63245	
	125068	4.5664	
	125513	9.9	
	M126183	382	
	M126349		11

DQA: ____________ Date: ____________

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date:

Work Order update only ☐

Work Order: ____________

Part No. ____________

NCR No. ____________

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function

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☐ Hardware
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☐ Out of Calibration
☐ Out of Sequence

☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other ____________

DART

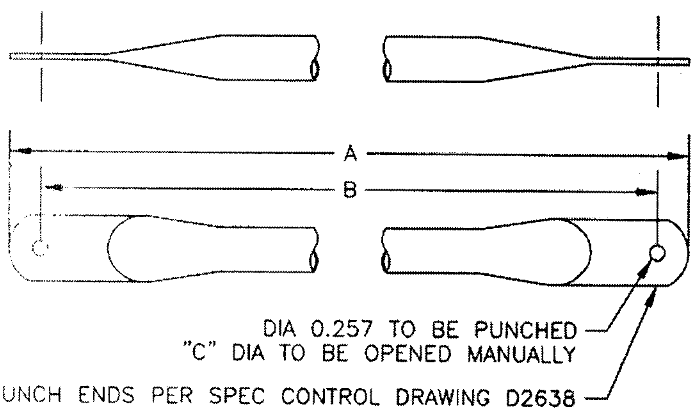
QA COPY ISSUED

DESIGN	DRAWN BY	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2565 — REV. E — SHEET 1 OF 1
DATE 04.05.05		TITLE STRUT — SCALE 1:3

REV	DATE	DESCRIPTION
A	96.05.03	NEW ISSUE
B	97.03.15	CORRECT D2565-111 DIM. A
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)
D	02.06.05	ADD -3XX PARTS; ADD FINISH
E	04.05.05	ADD D2565-401-411; RMV ANGLE D

RELEASED 04.05.05

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	–
D2565-109	12.31	11.51	–
D2565-111	13.65	12.85	–
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	–
D2565-209	15.16	14.36	–
D2565-211	14.14	13.34	–
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	–
D2565-309	20.17	19.37	–
D2565-311	16.30	15.50	–
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	–
D2565-409	9.34	8.54	–
D2565-411	13.81	13.01	–



GENERAL NOTES

1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL
   (REF DART SPEC. M304TR0.750W0.049)
   ENSURE SEAMLESS TUBE IS USED
2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE LTD

Description:	Strut	Work Order:	104572
Inspection Drawing:	D2565	Rev: E	Part Number: D 2565-105

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
20.19	+/- .030	20.19	✓		T	SB-5
19.39	+/- .020	19.39	✓		T	SB-5
Ø.316	+/- .005					
Ø.257	+/- .005					

Measured by: SB	Checked By: DAS 36 9-89	QC inspector: DAS 27 9-89	Engineering Approval (*if necessary*):
Date 13/10/10	Date 13/10/21	Date 13 10 21	Date